


Date: Monday, 25/09/2006 2:52:40 PM
 User: Linda Lacelle

Process Sheet

Customer	: CC-DAR01 Dart Aerospace Ltd.	Drawing Name	: D3121044
Job Number	: 28718		
Estimate Number	: 10804		
P.O. Number	: N/A	Part Number	: Z_CUSTOM
This Issue	: 25/09/2006 S.O. No. : N/A	Drawing Number	: DISASSEMBLE
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: N/A Type : OVERHEAD	Drawing Revision	: N/A
Previous Run	: 00015	Material	: N/A
Written By	: 	Due Date	: 02/10/2006
Checked & Approved By	: _____	Qty:	2 Um: Each
Comment	: _____		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

REMOVE FROM STK

2 X D3121-044 B 21379

1X D3121-044 B 24678

U 06-09-25

606-0-031

2.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1

REMOVE D3121-21 BOLT FROM D3121-044

D3121-044 B 2x B21378/79

ADJ ACCPAC 1x B24678

SB 06/10/03

SB 06/09/25

3.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1

RE-ASSEMBLE D3121-21 BOLT WHEN AVAILABLE

D3121-21 B 29698

MF 07-01-04

4.0	D312121	Bolt
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Comment: Qty.: 2.0000 Each(s)/Unit Total: 4.0000 Each(s)

Bolt B 29698

5.0	QC5	INSPECT WORK TO CURRENT STEP
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Comment: INSPECT WORK TO CURRENT STEP

07-01-04 (3)

Date: Monday, 25/09/2006 2:52:40 PM
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Process Sheet

Customer: CC-DAR01 Dart Aerospace Ltd.

Drawing Name: D3121044

Job Number: 28718

Part Number: Z_CUSTOM

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

RETURN TO STK USING NEW B/N *

574.9

PC 7/1/05

(3)

7.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

SP 07/01/08

Job Completion



U 07/01/08

39

DART AEROSPACE LTD		Work Order:	21378/79
Description: Bracket Assembly		Part Number:	D3121-043
04.08.23/14 C2 E 04.02.19 14/15 04.08.23/14			D3121-044
Dwg: D3121 Rev. B page 1, 3, 5		Qty:	4 Kits
D3121-043 replaces Premier P/N B30-23000-37			
D3121-044 replaces Premier P/N B30-23000-38			Page 1 of 1

Step	Location	Procedure	By	Date	Qty
1	DC	Issue Traveler	LD	04.08.23	4
2	MV	Cut (1) blank per D3121-13 & (1) blank per D3121-14 Cut blanks (1.00" x 2.00") x 3.250" Long Bar Material: 17-4 SS per AMS 5604/5643 (M17-4-B1.000x02.000) Batch: <u>M14773</u>	ML	04/09/20	4
3	MV	Machine D3121-13 as per Folio FA329 and Dwg D3121	EE	04.11.16	4
4	QC2	Inspect parts as they come off the CNC machine	EE	04.11.16	4
5	MV	Machine D3121-14 as per Folio FA329 and Dwg D3121	EE	04.11.16	4
6	QC2	Inspect parts as they come off the CNC machine	EE	04.11.16	4
7	MV	Deburr Break all sharp edges 0.005 to 0.015	EE	04.11.16	4
8	MV	Scribe batch number to D3121-13 & D3121-14 at the back face.	LD	05.01.20	4
9	QC5	Second check D3121-13 and D3121-14	UP	05/01/24	4
10	GA	Assemble D3121-043 as per Dwg D3121 Pick: 2 D3121-21 Qty Part Number Description Batch 2 D3121-17 Washer B21881A 2 D3121-19 Bearing 2 MS24694-S50 Screw B21855 2 D3121-241	UP	04/12/08	4
11	GA	Assemble D3121-044 as per Dwg D3121 Pick: 2 D3121-21 Qty Part Number Description Batch 2 D3121-17 Washer B21881A 2 D3121-19 Bearing 2 MS24694-S50 Screw B21855 2 D3121-241	EE	05.01.24	4
12	QC5	Inspect work to Step 10 & 11	LD	05.01.24	4
13	ST	Identify and Stock in Spacedoor cell D3121-043 Qty 4 D3121-044 Qty 4	LD	05.01.27	4
14	AC	Parts to Stock and Prorate Cost to parts per Step 13 Cost / part 129.18 129.22	SAC	05.01.27	4
15	DC	Close W/O 92.14 129.22 Inspect Level 21	LD	05.02.28	4

Rev	Date	Change	Revised By	Approved
A	02.05.21	New issue	NG	
B	03.05.02	Reformat	KJ/RF	

REFERENCE ONLY

RELEASED
03.05.06

5/46

DART AEROSPACE LTD	Work Order:	24678
Description: Bracket Assembly	Part Number:	D3121-043
		D3121-044 ✓
Dwg: D3121 Rev. C2 page 1, 3, 5	Qty:	4 Kits
D3121-043 replaces Premier P/N B30-23000-37		
D3121-044 replaces Premier P/N B30-23000-38		Page 1 of 1

Step	Location	Procedure	By	Date	Qty
1	DC	Issue Traveler Dwg not required	JS	05.10.26	4
2	MV	Cut (1) blank per D3121-13 & (1) blank per D3121-14 Cut blanks (1.00" x 2.00") x 3.250" Long Bar Material: 17-4 SS per AMS 5604/5643 (M17-4-B1.000x02.000) Batch: M14773	J.L.	05.11.14	8
3	MV	Machine D3121-13 as per Folio FA329 and Dwg D3121	J.L.	05.11.17	4
4	QC2	Inspect parts as they come off the CNC machine	J.L.	05.11.17	4
5	MV	Machine D3121-14 as per Folio FA329 and Dwg D3121	J.L.	05.11.18	4
6	QC2	Inspect parts as they come off the CNC machine	J.L.	05.11.18	4
7	MV	Deburr Break all sharp edges 0.005 to 0.015	J.L.	05.11.18	4
8	MV	Scribe batch number to D3121-13 & D3121-14 at the back face.	J.L.	05.11.18	8
9	QC5	Second check D3121-13 and D3121-14	me	05/11/18	8
10	GA	Assemble D3121-043 as per Dwg D3121 Pick: Qty Part Number Description Batch 2 D3121-21 Bolt B244758 2 D3121-241 Bearing Assembly B24777 Identify as D3121-043	B6	05.11.20	4
11	GA	Assemble D3121-044 as per Dwg D3121 Pick: Qty Part Number Description Batch 2 D3121-21 Bolt B244758 2 D3121-241 Bearing Assembly B24777 Identify as D3121-044	B6	05.11.20	4 + 4
12	QC5	Inspect work to Step 10 & 11	B6	05.11.20	4 + 4
13	ST	Identify and Stock in Spacedoor cell Loc 402 D3121-043 Qty 4 D3121-044 Qty 4	B6	05/11/21	4 + 4
14	AC	Parts to Stock and Prorate Cost to parts per Step 13 Cost / part: _____			
15	DC	Close W/O Inspect Level 21	JP	05/11/23	8

Rev	Date	Change	Revised By	Approved
A	02.05.21	New issue	NG	
B	03.05.02	Reformat	KJ/RF	
C	05.01.27	Revised Steps 10-11	KJ/JLM	

RELEASED
05.11.20

Qty
159
2